

Work Order ID 67788

Wednesday, March 30, 2011 11:34:27 AM



Page 1

Item ID: D3488-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Blade Fitting Assembly, LH

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: HL Date: 11-03-30 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3488	Rev B
-------	-------

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Dwg DSK 101 & Folio FA625□2-Debur

ml 11.4.7

6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 11.4.7

6

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA625 & Dwg D3488□2-Debur

A.A 11/04/14

6

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3488-041

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Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B.A 11/04/14

6

φ

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

mr 11/04/15

6

φ

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6

φ

11/04/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 67788

Wednesday, March 30, 2011 11:34:27 AM



Page 3

Item ID:	D3488-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Blade Fitting Assembly, LH					
Start Date:	3/30/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	4/4/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M116964.</i>	0.00							
Powdercoat	Memo	0.00				<i>6</i>		<i>BL 11-4-20.</i>	
Powder Coating	START TIME: <i>11:00</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>11:30.</i>								
170 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				<i>6</i>	<i>φ</i>	<i>11-4-20</i>	
Quality Control									
180 	HandFinishing	0.00							
HandFinish	Memo	0.00				<i>6</i>	<i>φ</i>	<i>11-4-20</i>	
Hand Finishing	Install Inserts as per Dwg D3488								

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 67788

Wednesday, March 30, 2011 11:34:27 AM



Page 4

Item ID: D3488-041

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Item Name: Blade Fitting Assembly, LH

Start Date: 3/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 11/05/13



Quality Control

200

Identify as per dwg & Stock Location: FP-8

0.00



Packaging

Memo

0.00

x6 11/05/13

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/5/16

Quality Control

MF
11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 30, 2011 11:34:33 AM

Work Order ID: 67788



Parent Item: D3488-041



Parent Item Name: Blade Fitting Assembly, LH

Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-02-28 JLM
IPP Rev:B As per Rev B 06-03-30 JLM
IPP Rev:C Now On Doosan Lathe JLM Verified BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-225 Purchased No Each 700.0000



48

Handwritten: 11.4.7
11/05/12

INSERT

Location

Loc Qty

Loc Code

ST282

700

M110768

x24

100896

100

111529

300

111581

300

D6103-003

Manufactured No

Each

6.0000

12



Handwritten: 11.4.7

Round Billet, Aluminum

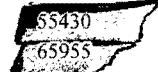
Location

Loc Qty

Loc Code

MAT043

6



Handwritten: 3
3

Handwritten: 3
3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67788
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number: D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
Ø2.150	+/-0.005	2.147	/		20.02	
Ø2.780	+/-0.005	2.777	/			
Ø3.125	+/-0.010	3.122	/			
Ø3.346	+/-0.010	3.346	/			
0.125 x 45°	+/-0.010 x +/-0.1°	.130	/			
8.000	+0.030/-0.000	8.018	/			
9.250	+/-0.010	9.250	/			
0.188	+/-0.010	.188	/			
R0.032	+/-0.010	.032	/			
R0.062	+/-0.010	.062	/			
Ø0.297	+0.005/-0.001	.299	/			
Ø0.430 X	+/-0.010	.430	/			
0.100	+/-0.010	.100	/			
0.125	+/-0.010	.127	/			
2.620	+/-0.010	2.618	/			
3.500	+/-0.010	3.500	/			
1.005	+/-0.010	1.005	/			
Ø0.484	+0.005/-0.001	.484	/			
1.180	+/-0.010	1.180	/			
3.150	+/-0.010	3.150	/			
3.070	+/-0.010	3.070	/			
R0.063	+/-0.010	.063	/			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	97788
Description: Blade Fitting, LH / Turning Detail for D3488-1/-2		Part Number:	D3488-1
Inspection Dwg: D3488 / DSK101 Rev: B / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	Ø0.509	-		Vern	6A-01
0.750	+/-0.010	0.754	-		H-G	31006
1.500	+/-0.010	1.500	-		Vern	6A-01
11.18	+/-0.030	11.183	-		H-G	31006
R0.062	+/-0.010	R0.063	✓		R-G	ref.
0.125	+/-0.010	0.130	✓		Vern	6A-01
0.590	+/-0.010	0.592	✓		H-G	31006
0.793	+/-0.010	0.798	✓		"	"
1.351	+/-0.010	1.346	✓		"	"
1.317	+/-0.010	1.320	✓		Vern	6A-01
1.802	+/-0.010	1.802	✓		H-G	31006

Measured by:	B.A	Audited by:	cmh	Prototype Approval:	N/A
Date:	11/04/14	Date:	11/04/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-041	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: / _____ Date: _____

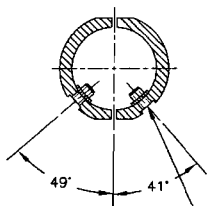
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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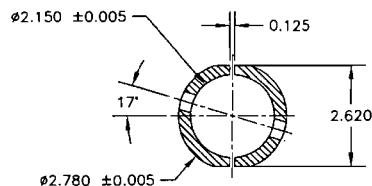
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67286*

PH 11-0330



SECTION B-B

Ø0.297
C'BORE Ø0.430 x 0.100
INSTALL ALS4-1032-225 (OR AKS4-1032-225
OR ALS7-1032-225 OR AKS7-1032-225)
INSERTS AFTER FINISH
(4 PLACES)



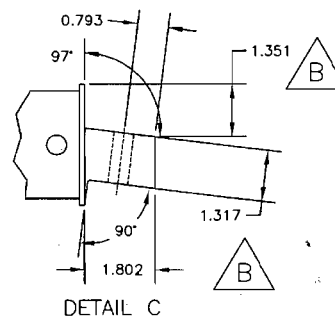
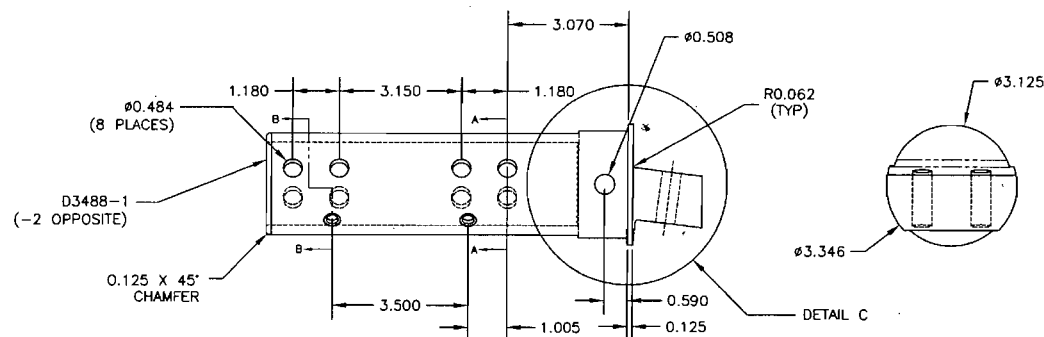
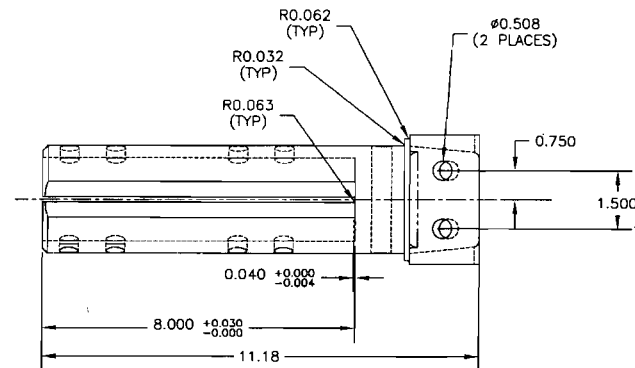
SECTION A-A

D3488-041/-042 BLADE FITTING ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D3488-041	BLADE FITTING ASSEMBLY (LH)
		D3488-042	BLADE FITTING ASSEMBLY (RH)
1		D3488-1	BLADE FITTING (LH)
	1	D3488-2	BLADE FITTING (RH)
4	4	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

D3488-041/-042 BLADE FITTING

- MATERIAL: MAKE D3488-1/-2 FROM ALUMINUM 7075-T7351 ROUND BAR
PER QQ-A-225/9
(REF. DART MATERIAL SPEC M7075T73R)
- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- BREAK UNMARKED SHARP EDGES 0.010 TO 0.020
- INSTALL INSERTS AFTER POWDER COAT
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3488-041 SHOWN (D3488-042 OPPOSITE)

RELEASED
06.03.15 PH
REV. 05
ECN #737

B	06.03.15	CHANGE THICKNESS
A	05.12.20	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED PH
DATE	06.03.15	TITLE
		BLADE FITTING
		DART AEROSPACE USA, INC.
		PORT HADLOCK, MA
		REV. B
		SHEET 1 OF 1
		SCALE
		1:3

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DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
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